

Date: Monday, 07/04/2008 11:46:54 AM
 User: Julie Lecoq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP (CASTING DETAIL)
Job Number	: 38420		
Estimate Number	: 11088		
P.O. Number	:	Part Number	: D25761
This Issue	: 07/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2576 REV G
First Issue	: / /	Project Number	: N/A
Previous Run	: 33320	Drawing Revision	: G
Written By	:	Material	:
Checked & Approved By	: <u>JD 08.04.06</u>	Due Date	: 14/04/2008
Comment	: Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC Est Rev:C As per Rev G 07-09-05 JLM Verified By:EC	Qty:	100 Um: Each

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>6082</u> Ship D2576 mould to vendor Cast per D2576-1 Pattern Material Release Note Required <u>CL08/04/07</u> <u>100</u>		
2.0	D25761P	Step (Casting Detail)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) STEP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure D2576 mould is returned with the ordered parts Ensure release note is attached <u>12/4/28</u> <u>100</u>		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK <u>J.L 08/05/23</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



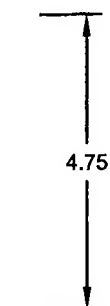
Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion

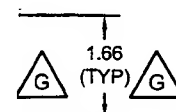


MF 08-05-27



3







K 1.28 SLOT



RELEASED

07.08.29

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO.
MFG. APPR.		D2576
APPROVED		TITLE
DE APPR.		STEP
DATE	07.08.15	

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ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA**Ship To:** DART AEROSPACE

Order Date		Purchase Order#	Due Date	Ship Via			P
07-Apr-2008		PO00006082	25-Apr-2008	FEDEX			
Item#	Item Code	Description	Material	Ordered	B/O	Qty	
1	DART D2576	D2576 STEP CSTG		100			
2							

Comments

Castings&Patterns are property of Alpine until paid in full

Apr 23/08

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE

MAR 03 2008

CONFORMS TO ASTM SPECIFICATION: B179-06

Alloy: 535.2

Heat: A7880

Si	0.060
Fe	0.057
Cu	0.007
Mn	0.128
Mg	6.990
Cr	0.001
Zn	0.011
Ti	0.135
Sn	0.003
Pb	0.001
Ni	0.000
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-.25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-.25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakrzewski

RON ZAKRZEWSKI

LAB MANAGER

FM-12 01 Rev D 12/5/2001

MAR 03 2008

DATE

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.